Work Orde Wednesday, May								*	45.				Page 1
Revision ID:	D3319-3 Wearplate					Accept.				S	Setup Star Sto	1 19011101 1	
Start Date: : : Required Date: : Reference:	5/11/2011 5/16/2011	Start Qty: Req'd Qty					Cust Iter				7		'
Approvals:	Process Plan	n:		Date: <u>/</u> Date:	1-05-1	Tooling: SPC (Y/N):		Date:		F	Run Stai Stoj V		1848 HJ 1451 HJ 1848 HJ 1451 HJ
Sequence ID/ Work Center ID		Operation Description				Set Up/ Run Hours	Tool II	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Waterjet FLOW CNC Waterje	t	1	.' Memo	er Dwg D3319 ecessary	□Dwg Rev	0.00 0.00 7: □ Prog Rev	□2-	; #.		1311-	5-35	(\$
QC Quality Control			parts off i	machine FAI/F	AIB	0.00				HBN:-	4-75	·	
QC Quality Control		QC8- Inspect	: parts - se	cond check	***	0.00 5 (lor/26			É		مر منتشد . 	

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Work Orde Wednesday, May													Page 2
Item ID: Revision ID: Item Name:	D3319-3 Wearplate				Accept					Setup S	Start Stop		
Start Date: Required Date: Reference:	5/11/2011 5/16/2011	Start Qty: 8.00 Req'd Qty: 8.00				Cust Item Customer				·			110 118 1181 1881
Approvals:	Process Plan	n:	Date:		Tooling: SPC (Y/N):		Date:]		Start Stop		
Sequence ID/ Work Center II 130 Small Fab Small Fab		Operation Description Small Fab Memo Deburr if r	necessary		Set Up/ Run Hours 0.00	Tool ID W \ A	Tool #	Plan Code	Accept Qty	Reject Qty		leject Jumber	Insp. Stamp
140 Brake NC Brake NC		NC BRAKE Memo Form using	3 DT8326 & I	OT8261 as per	0.00 0.00 Dwg D3319Rev: <u>b</u>	_ Sps (Il)e	a< 27		9		————————————————————————————————————		

150

QC6- Inspect dimensions to drawing

0.00 Sulcr177

Quality Control

Memo

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W/O:			W	ORK ORDER CHANG	ES			=	
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Work Order ID 69528

Wednesday, May 11, 2011 4:04:45 PM



Page 3

Item ID:

D3319-3

Accept

Setup Start

Stop

Stop



Revision ID:

Item Name:

Wearplate

Start Date: 5/11/2011 **Required Date: 5/16/2011**

Start Qty: 8.00

Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date:

Date: _____

Tooling: SPC (Y/N):

Date: Date:

Start Run

Sequence ID/ **Work Center ID**

160

Large Fab

Large Fab

Operation Description Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

11-08-10 JBL

Insp.

Large Fab

Memo

0.00

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev:

N/A

Memo

Memo

_□Qty Part Number Description 7560 Hardcoat Rod 18453

170

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

180

QC Quality Control QC5- Inspect part completeness to step on W/O

0.00

										
W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	DCEDURE CH	ANGE	Ву		Date C	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Work Order ID 69528

Wednesday, May 11, 2011 4:04:45 PM



Page 4

Item ID:

D3319-3

Accept

Setup Start



Stop

Item Name: **Start Date:**

Revision ID:

Wearplate 5/11/2011

Required Date: 5/16/2011

Start Qty: 8.00

Req'd Qty: 8.00



Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Tool # Plan

Run

Start

Stop

Sequence ID/ **Work Center ID**

190

Powdercoat

Powder Coating

Operation **Description**

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M 117338

Date:

Memo 1:30pm START TIME:

Set Up/ **Run Hours**

0.00

0.00

□OVEN TEMPERATURE:

2000 OFINISH TIME:

320°t

200

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

210

Packaging Packaging

Packaging

Memo

0.00

0.00

Identify on inside surface using a permanent fine point marker with the following: ☐TCCA-PDA, Dart Aerospace Ltd. ☐P/N: D3319-3, B/N: BXXXXX□For Product Eligibility see PDA05-18□and Stock□Location:

Code

Accept

Reject Qty Qty

Reject Number

Insp. Stamp

W/O:	•		WC	RK ORDER CHANG	ES				
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Work Order ID 69528

Wednesday, May 11, 2011 4:04:45 PM



Page 5

Item ID:

D3319-3

Accept



Setup Start



Revision ID:

Item Name:

Wearplate

Start Date: 5/11/2011 Start Qty: 8.00

Required Date: 5/16/2011

Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Memo

Date: Date:_____

Tooling:

SPC (Y/N):

Date:_

Date:

Run

Start

Stop

Stop

Sequence ID/

Work Center ID

220

Quality Control

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan

Accept Code Qty

Reject Qty

Reject Number Stamp

Insp.

W/O:			WC	ORK ORDER CHANG	ES								
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Wednesday, May 11, 2011 4:04:52 PM

Work Order ID: 69528

Parent Item:

D3319-3

Parent Item Name:

Wearplate



Start Date: 5/11/2011

Required Date: 5/16/2011

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP: A□05.05.12□New issue□KJ/JLM□

IPP Rev:B Now on Waterjet 06-10-03 JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased	No			100	sf	26.5000	3.2524	27.38863	3		
											811-5-2	5	

1010/1025 SHEET .048

 Location
 Loc Oty
 Loc Code

 MAT019
 26.5
 116268

 26.5
 26.5

117806

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DART AEROSPACE LTD	Work Order:	69528
Description: Wearplate	Part Number:	D3319-3
Inspection Dwg: D3319 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
75.52	+/-0.030	75,57	6		T BUZ	
74.420	+/-0.010	74.470	8		7	
62.770	+/-0.010	65.770	2		7	
52.890	+/-0.010	57. KG	3		7	
30.790	+/-0.010	30,790	>		T	
8.690	+/-0.010	8.690	7		7	
0.60	+/-0.030	,598	6		1/ 1801	
2.690	+/-0.010	7.693	ک		V	
2.940	+/-0.010	2947	ъ		ν	
3.527	+/-0.010	3,527	×		V	
4.518	+/-0.010	4.514	>		V	
Ø0.190	+0.005/-0.001	ृ।५५	>		1/	
2.940	+/-0.010	2949	> 0		Ŭ	
2.940	+/-0.010	29.47	8		v .	
2.690	+/-0.010	2.696	8		ν	
5.063	+/-0.010	5.056	>		V	
6.163	+/-0.010	6.161	7		V	
Ø0.316 x 0.607	+0.006/-0.001 x +/-0.010	317×69	ъ		ν	
0.048	+/-0.010	,0460	>		ν	
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Measured by:	B	Audited by:		Prototype Approval:	N/A	
Date:	11-5-26	Date:	105/26	Date:	N/A	

Rev	Date	Change	Revised by	Approved
Α	07.07.18	New Issue	KJ/JLM	E
•			7/1	

W/O:			WC	ORK ORDER CHANG	GES				
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WEARPLATE

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D3319 DRAWING NO.

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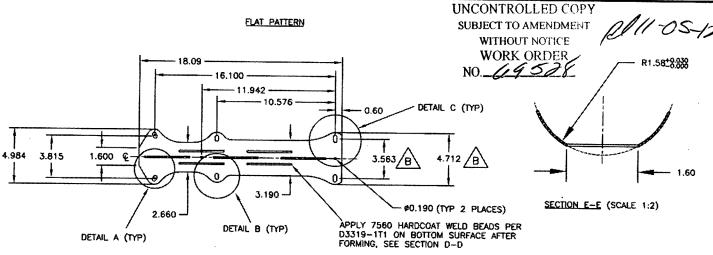
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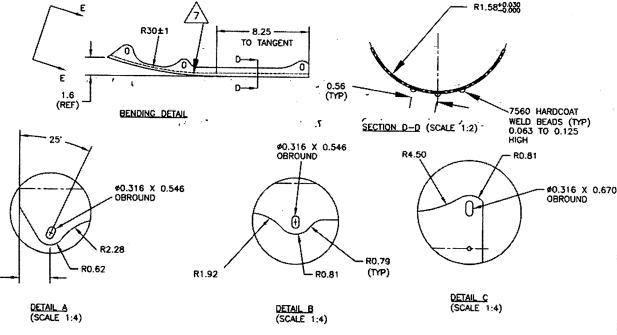
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DART AEROSPACE
HAWKESBURY, ONTARIO, CANA

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03319-1 WEARPLATE

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- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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PURPOSE

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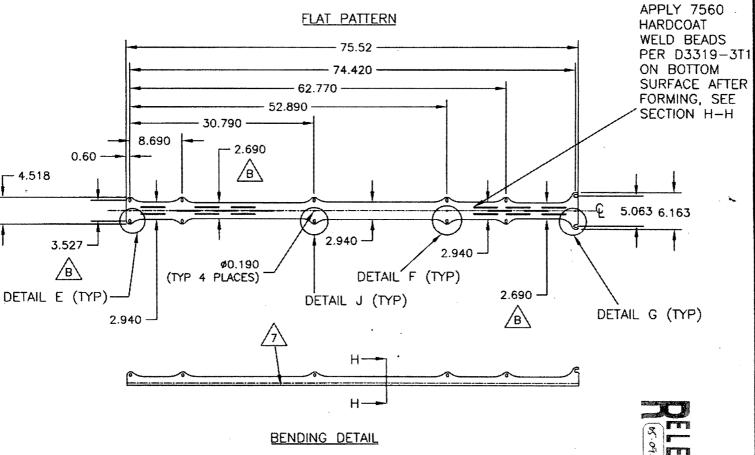
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D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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PURPOSE

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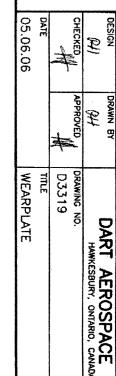
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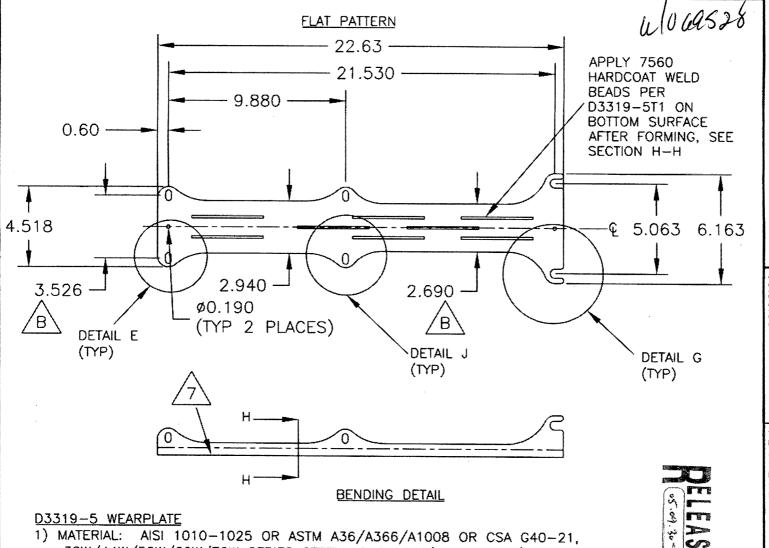
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- 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3 2) FINISH:
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004

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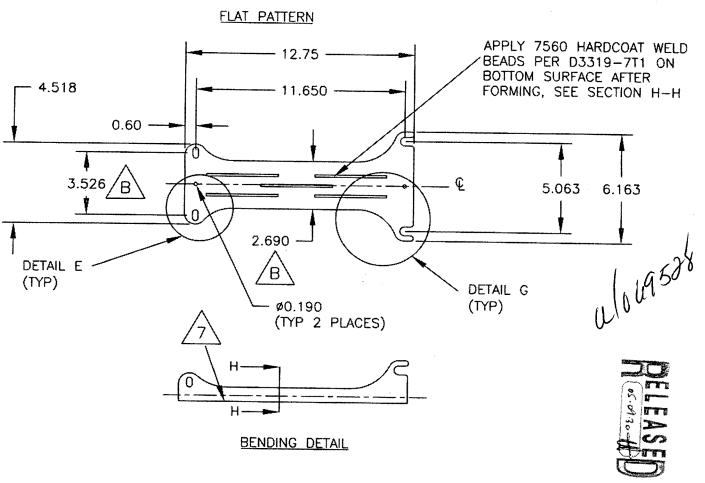
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7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX. FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

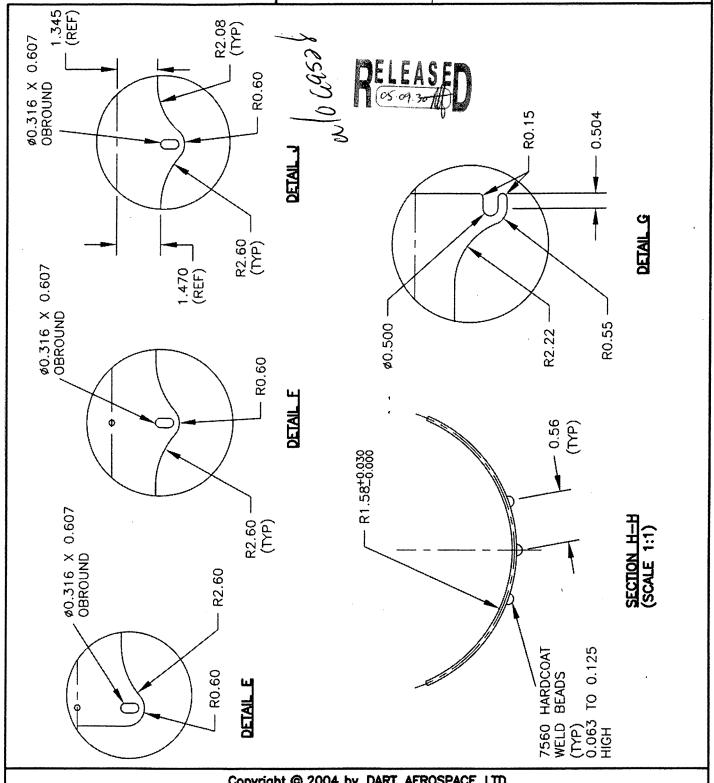


WEARPLATE 1:5		05.06.06	
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CHECKED	APPROVED ,	DRAWING NO.	REV. B
1 4	#	D3319	SHEET 5 OF 5
DATE		TILE	SCALE
05.06.06		WEARPLATE	1:3



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